

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001974**Date Inspected:** 17-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b> Yes No N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b> Yes No N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b> Yes No N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b> Yes No N/A
				<b>Delayed / Cancelled:</b> Yes No N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	Tower and OBG Fabrication	

**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

CWI Inspector: An Qing Xiang

Orthotropic Box Girder (OBG) and Tower Fabrication:

**New Tower Shop**

The QA Inspector observed ZPMC welder Mr. Sun Bingfa stencil 62046 is using welding procedure specification WPS-B-T-2221-B-L3C-S to make submerged arc groove weld SSDI-SA178 C/D-23A. The QA Inspector observed a welding current of approximately 660 amps, 33.5 volts, a travel speed of 590 mm per hour, and the base material is between 110°C and 230°C. Items observed by the QA Inspector appear to comply with project specifications.

ZPMC personnel informed Caltrans QA Inspectors that ZPMC is going to be performing radiography in bays 2 through 7 and that all personnel should stay away from this area.

New OBG fabrication shop.

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

The QA Inspector did not observe any personnel performing welding of CalTrans materials in the OBG fabrication shop.



### Summary of Conversations:

See above for summary of conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Dawson,Paul	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

---